

Work Order ID 75318

October-20-11 11:34:08 AM

75318

Page 1

Item ID: D3682-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket
 Start Date: 20/10/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 08/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: VLJ Date: 11/10/20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3682	Rev A

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3682Dwg Rev: A Prog Rev: A 2-Deburr if necessary

B11-11-1

(3)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

B11-11-1

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

11-11-02 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>8/18</i>	0.00							
130						<i>SP</i>	<i>11-11-03</i>		
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140								<i>11/11/3</i>	<i>[Signature]</i>
QC	Memo	0.00							
Quality Control									

11-11-3
(3)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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D3682-1

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ecn1162 08-04-02 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
G89		Purchased	No			110	sf	35.0000	0.3103	0.653263	1.5		
G89									**				
coated cloth											B11-11-1		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				(3)	
				MAT050		35							
				117666		35				117666			

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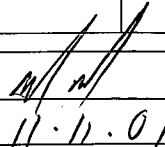
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	75318
Description: Gasket		Part Number:	D3682-1
Inspection Dwg: D3682 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.250	+0.005/-0.001	.254	>		✓ ID02	
0.75	+/-0.030	.741	2		✓	
1.247	+/-0.010	1.240	x		✓	
1.943	+/-0.010	1.951	x		✓	
3.875	+/-0.010	3.877	1		✓	
6.45	+/-0.030	6.444	✓		✓	
1.583	+/-0.010	1.579	2		✓	
1.820	+/-0.010	1.825	2		✓	
3.920	+/-0.010	3.918	2		✓	
7.152	+/-0.010	7.148	>		✓	
8.20	+/-0.030	8.190	>		✓	
0.993	+/-0.010	.991	2		✓	
1.900	+/-0.010	1.908	x		✓	
3.759	+/-0.010	3.757	x		✓	
0.38	+/-0.030	.383	2		✓	

Measured by: B	Audited by: 	Prototype Approval:	N/A
Date: 11-1-1	Date: 11.11.01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD 	

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

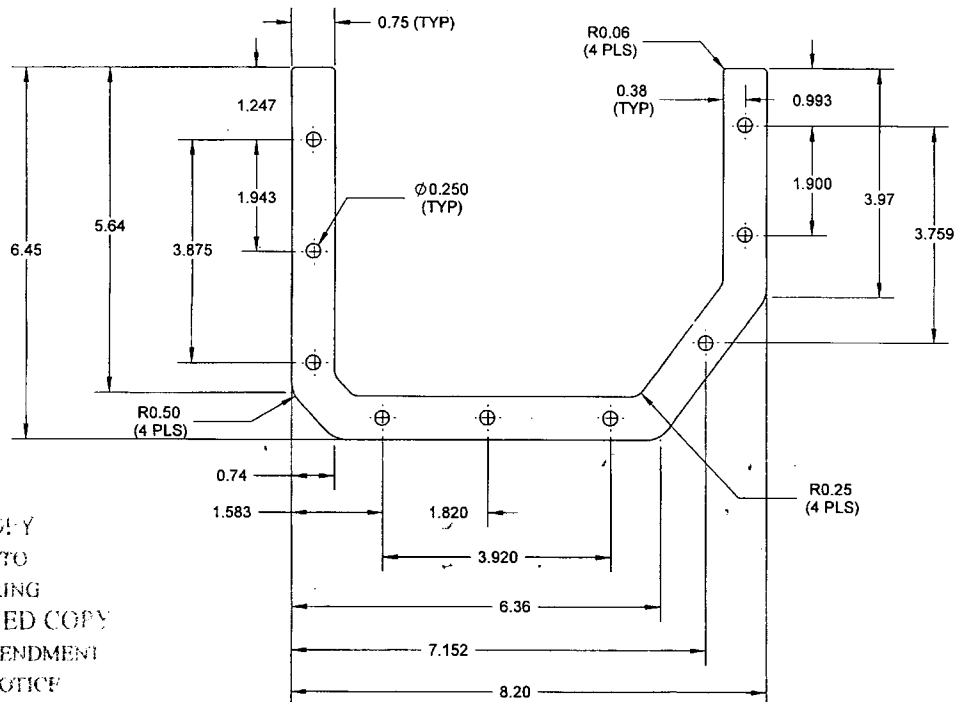
NO. 75318 M.L.J

11/10/20

D3682-1 GASKET

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89. (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3682-1 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs



A	NEW ISSUE	RF	07.11.07	
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3682 TITLE GASKET COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. A	
DRAWN	RF		SHEET 1 OF 1	
CHECKED	LE		SCALE	
MFG. APPR.	MP		1:2	
APPROVED	11/10			
DE APPR.	TH			
DATE	07.11.07			

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